

Work Order ID 110163

December-17-13 9:17:11 AM

110163

Page 1

Item ID: D4526-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step Assembly
 Start Date: 12/17/13 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4526	A								
100	Pick Kit	0.00				<u>2</u>			<u>14/01/30</u> DAS 36 9-89
100									
Packaging	Memo	0.00							
Packaging									
110		0.00				<u>2</u>			<u>14/01/30</u> DAS 36 9-89
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00				<u>2</u>			
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

14/11/30

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Item ID: D4526-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step Assembly

Start Date: 12/17/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00				2x	DAS 28 9-89	14-01-30	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-02-03

① 14-01-31

Picklist Print

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Work Order ID: 110163
Parent Item: D4526-042
Parent Item Name: Maintenance Step Assembly

Start Date: 12/17/13 Required Date: 12/17/13
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No			100	Each	5.0000	2	4		14/01/30	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST270		5							
				108408		3							
				74303		1							
				77852		1							
D4526-043 Tube Assembly		Manufactured	No			100	Each	4.0000	1	2		14/01/30	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST254		4							
				80087		3							
				82317		1							
D4527-1 Bracket		Manufactured	No			100	Each	3.0000	1	2		14/01/30	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST201		3							
				92876		3							
D4527-3 Bracket		Manufactured	No			100	Each	3.0000	1	2		14/01/30	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST201		3							
				92877		3							

B110087 (42)

1
1

2

2

Picklist Print

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Work Order ID: 110163
 Parent Item: D4526-042
 Parent Item Name: Maintenance Step Assembly

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

MS21042L3 Purchased No

100 Each 6,342.0000 10 20

~~14/01/30~~ DAS 36 9-89

Location	Loc Qty	Loc Code
GA	194	
M126333	194	
ST314	28	
M126036	28	
ST506	793	
123900	793	
ST509	4000	
M127304	1000	
M127410	3000	
ST510a	1327	
M126275	8	
M126333	1319	

MS24694-S55 Purchased No

100 Each 197.0000 8 16

~~14/01/30~~ DAS 36 9-89

Location	Loc Qty	Loc Code
ST303	197	
m127305	97	
m127327	100	

MS24694-S75 Purchased No

100 Each 25.0000 2 4

~~14/01/30~~ DAS 36 9-89

Location	Loc Qty	Loc Code
GA	1	
119892	1	
ST303	24	
121415	24	

Picklist Print

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Work Order ID: 110163
Parent Item: D4526-042
Parent Item Name: Maintenance Step Assembly

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

100

Each

2,579.0000

10

20

14/01/30

DAS

Washer

36

9-89

Location

Loc Qty

Loc Code

ST293

964

m127374

70

m127431

894

ST294

215

122973

57

m125807

158

ST510a

1400

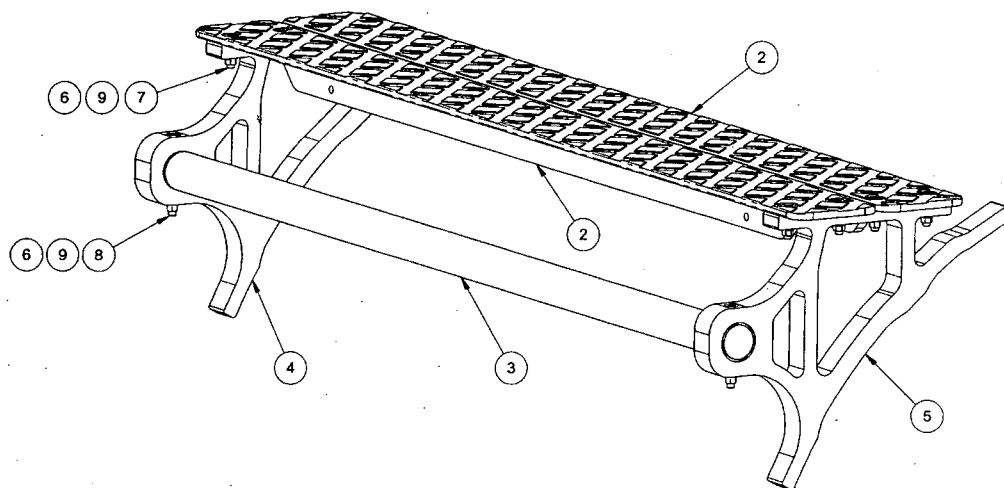
m127374

400

m127389

1000

20



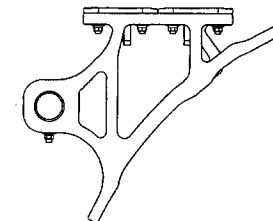
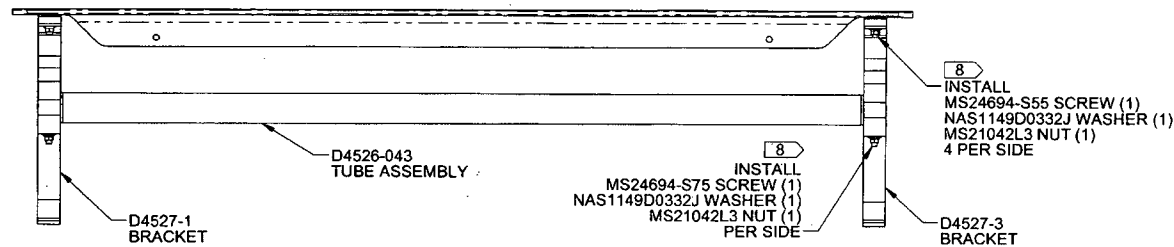
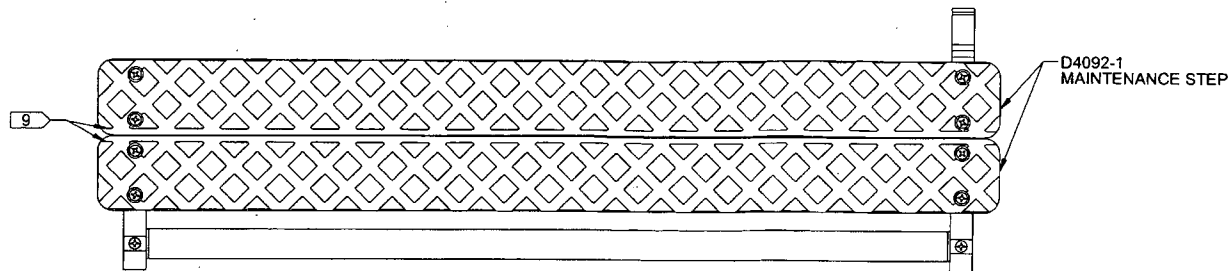
D4526-042 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D0332J	WASHER

110163 MCT
13-12-18

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2011-11-28
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A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	CH	DRAWING NO.	REV. A
MFG. APPR.	CH	D4526	SHEET 1 OF 5
APPROVED	CH	TITLE	SCALE
DE APPR.	CH	MAINTENANCE STEP ASS'Y	NTS
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D4526-042 MAINTENANCE STEP ASSEMBLY

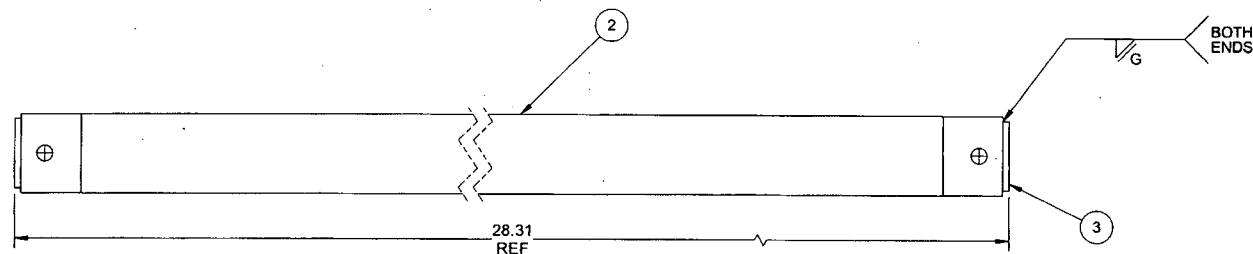
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2011-11-28
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 7.09 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP



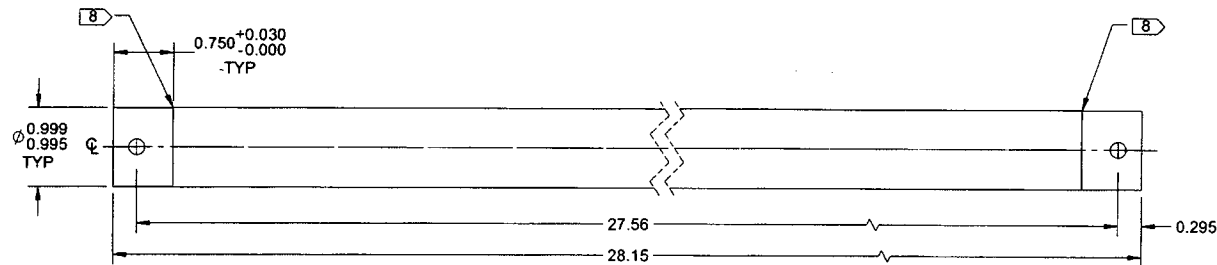
D4526-043 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) WELD PER QSI 004

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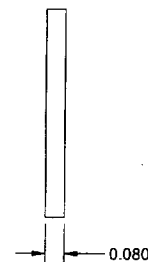
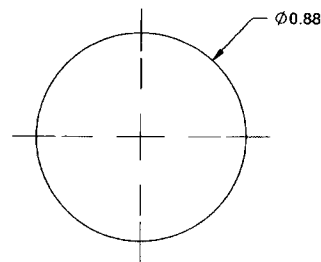
D4526-1 TUBING

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

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[Signature]



D4526-3 CAP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.005 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	
DATE	11.11.22	NTS	

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